

Work Order ID 75951

November-02-11 8:48:19 AM

75951

Page 1

Item ID: D3643-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Stiffener

Start Date: 11/01/11

Start Qty: 8.00

8

Cust Item ID:

Required Date: 11/04/11

Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: 

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3643	Rev A								

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3643 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

B1-11-2

(10)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B1-11-2

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

11.11.02 (10)

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Item ID: D3643-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Stiffener
 Start Date: 11/01/11 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 11/04/11 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo Form as per Dwg D3643	0.00 0.00				(10)			
140 *140* Small Fab Small Fab	Small Fab Memo C'sink as per Dwg D3643	0.00 0.00							
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

SB 11/11/02

SB 11/11/02 (10)

W 11 - 11 - 02 (10)

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N900040100

Setup Start ***NS1***

Stop ***NS2***

8

8

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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0.00

0.00

Memo

0.00

0.00

Memo

0.00

0.00

Memo

Packaging

Work Order ID 75951***75951***

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Item ID: D3643-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Stiffener

Start Date: 11/01/11 Start Qty: 8.00

8

Cust Item ID:

Required Date: 11/04/11 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

11/11/11 [Signature]
R 11-17-04
10

Picklist Print

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Page 1

Work Order ID: 75951

Parent Item: D3643-1

Parent Item Name: Stiffener

Start Date: 11/01/11

Required Date: 11/04/11

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No			100	sf	102.3184	0.1475	1.2421053	1.15		
						<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
						MAT022		102.318421					
						117684		102.318421					

1311-11-2

117684

10


DART AEROSPACE LTD		Work Order:	73951
Description: Stiffener		Part Number:	D3643-1
Inspection Dwg: D3643 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

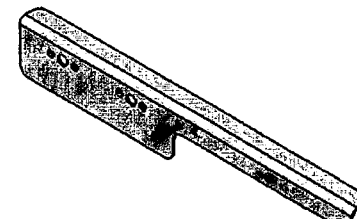
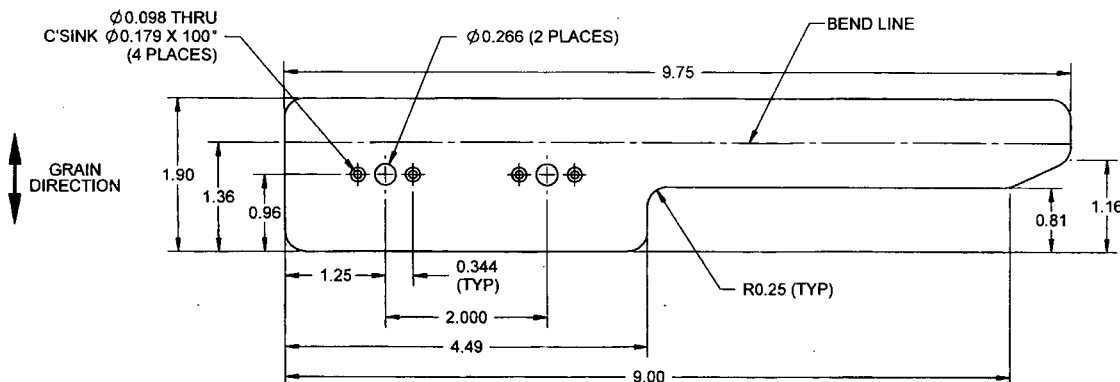
X

Prototype

[illegible]

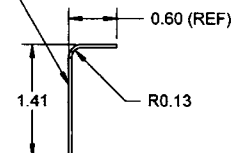
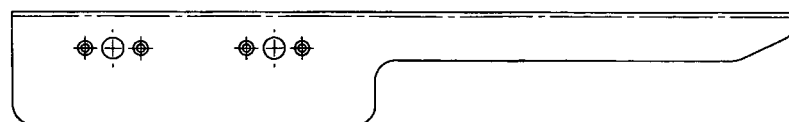
Measured by: B	Audited by: 	Prototype Approval: N/A
Date: 11-11-2	Date: 11.11.02	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	



**D3643-1F FLAT PATTERN
(D3643-2F OPPOSITE)**

ENSURE THAT COUNTERSINKS
ARE ON THIS SIDE OF THE PART



**D3643-1 STIFFENER (REPLACES GENEVA P/N G10610-2)
D3643-2 OPPOSITE (REPLACES GENEVA P/N G10610-1)**

W6 75951

RELEASED
07.09.07

- NOTES:
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3643-1/-2" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.06 lbs

A	NEW ISSUE; REPLACES G10610	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DTI		
DRAWN	LE		
CHECKED	LE		
MFG. APPR.	LE		
DE APPR.	LE		
DATE	07.07.27		
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